

Date: Wednesday, 11/16/2005 1:06:26 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 24209		
Estimate Number	: 10437		
P.O. Number	: PIA	Part Number	: D33191
This Issue	: 11/16/2005	S.O. No.	: PIA
Prsht Rev.	: NC	Drawing Number	: D3319 REV. B
First Issue	: N/A	Project Number	: PIA
Previous Run	: 23340	Drawing Revision	: B
	Type	Material	: PIA
	: PURCHASED PARTS	Due Date	: 11/23/2005
Written By	: See comment below	Qty:	1
Checked & Approved By	: See comment below	Um:	Each
Comment	: Est: B 05.10.14 Added step 9, dwg rev B KJ/EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 2008540

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D3319

Possible Supplier: Industrial Laser

Material release note is required

2.0	D33191F	Wearplate
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(B24376)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 WEARPLATE

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

N/A

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6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

2- Form flat on press using DT8776 block

SB 05/12/06

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

05/12/06

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Layout weld location as per Dwg D3319 using jig D3319-1T3

2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: B

Qty Part Number Description

Batch

A/R N/A

7560 Hardcoat Rod

M19172

CAL 05-02-06

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

05/12/07

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FL 05 12 20

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

ML 05 12 21

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: 88

06/01/07

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Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/05 (1)

LD 06/01/05 (1)

Job Completion



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
11:10 am

Work Order No : 0024209
Project Name : D3319-1
Project For : WK537
Work Order Type : Main
Main WO Number :
House Part Number : D3319-1
Description : Wearplate
Manufactured : Yes
Amount Req'd : 4
Amount Done : 2
Start Date : 09-02-05
Est Finish Date : 09-12-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%

Part/All Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	25.76	100.00	25.76	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	8.42	100.00		
Production Cost :	0.00	152.75	100.00	55.36	97.39
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	178.51	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	178.51			

Labour Hrs/Amount Done : Estimated 0.00 Actual 4.21
Profits/(Loss) : 0.00 (-178.51)

MS JB
11/16